

<b>GEARTECH</b>	CHECKLIST			No. CK9305	SHEET 1 OF 3
				Rev. A	
Gearbox Bearing Removal and Inspection				BY RLE	DATE 7/05/98
				CKD JRM	DATE 7/05/98
DISASSY PLAN/PREPARATION					
Question	Y	N	R	Comments	
Is there an assembly drawing?					
Review assembly drawing with technician?					
Are all necessary tools available?					
Does technician understand need to proceed at pace that is slow enough to gather data?					
Is notebook ready for documenting procedure & recording observations?					
Is camera ready for documenting procedure & recording observations?					
HOUSEKEEPING					
Question	Y	N	R	Comments	
Is disassy area clean and uncluttered?					
Take oil samples from gearbox?					
Is area around gearbox clean?					
Is gearbox free of debris, tools, rags, and unnecessary hardware?					
Are gearbox breathers installed?					
When opening ports are the following precautions followed:					
Open ports one at a time?					
Clean inspection cover & area around port before opening?					
Count inspection cover bolts before opening?					
Keep inspection cover bolts in separate containers?					
Technicians have nothing in shirt pockets?					
Flashlights & tools on lanyards?					
Ports closed immediately after inspection?					
All inspection cover bolts accounted for?					
GEARBOX DISASSY					
Question	Y	N	R	Comments	
Match mark bearing retainer cap & housing?					
Photograph bearing retainer cap?					
Remove bearing retainer bolts following housekeeping rules?					

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				Rev. A	
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Question	Y	N	R	Comments	
Photograph interior of bearing retainer cap?					
Photograph visible parts of bearing?					
Photograph wear debris?					
Collect wear debris?					
Match mark bearing outer race and housing?					
Match mark bearing inner race and shaft?					
Complete disassy of gear housing?					
<b>GEAR/BEARING REMOVAL</b>					
Question	Y	N	R	Comments	
Photograph bearing in housing?					
Remove gears from housing being careful not to damage bearing?					
Photograph bearing on shaft?					
Check with feeler gauge to ensure bearing is against shaft shoulder?					
Remove bearing from shaft without pulling through outer race (use split puller)?					
<b>PREPARATION FOR SHIPMENT</b>					
Question	Y	N	R	Comments	
Do not clean bearing. Prepare for shipping in bearing's own oil?					
Wrap bearing in rust preventative paper?					
Wrap bearing in leak-proof plastic?					
Pack in sturdy carton?					
Ship by UPS to GEARTECH?					
<b>COMPONENT INSPECTION</b>					
Question	Y	N	R	Comments	
Inspect shaft diameter. Is diameter to drawing spec?					
Inspect bore diameter. Is diameter to drawing spec?					
Inspect shaft fillet radius. Is radius to drawing spec?					
Does new bearing have proper part number?					
Does new bearing have proper internal clearance?					
Are shaft diameter, housing bore, & interfaces free of burrs?					

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		Rev. A		
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BEARING/GEARBOX ASSEMBLY				
Question	Y	N	R	Comments
Heat bearing with hot oil or induction heater?				
Install on shaft and clamp against shaft shoulder while cooling?				
Check with feeler gauge to ensure bearing is against shaft shoulder after bearing is cool?				
Install gear/shaft assembly in gear housing without lifting through bearing?				
Install housing top cover?				
Install bearing retainer cap?				
Check bearing endplay?				
Spin test gearbox (see GEARTECH CK8800)?				